



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-2706-00-07
Job Sheet 181639



Part No: RBE350A94-2706-00-07

Job Qty: 20 ea *30*

DAS
21

Part Name: Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/2/18

Job Tracking No:

Due Date: 8/7/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A94-2706-00 REV 6 IPP REV A 18-01-16 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	8/7/18	8/7/18	0.00	0.00	Start Up Small Fab-2		<i>MLC</i>
110	Small Fab	20 pcs	8/7/18	8/7/18	0.00	10.00	Small Fab-3		<i>MLC</i> <i>DAS</i>
120	QC	20 pcs	8/7/18	8/7/18	0.00	0.00	QC5		<i>OCT 01 2018</i> <i>68</i>
121	Outsource	20 pcs	8/7/18	8/7/18			GRO002-VC	10	<i>OCT 01 2018</i> <i>68</i>
123	Packaging	20 pcs	8/7/18	8/7/18	0.00	0.00	Packaging2		<i>OCT 01 2018</i> <i>38</i>
125	QC	20 pcs	8/7/18	8/7/18	0.00	0.00	QC6		<i>38</i>
127	Small Fab	20 pcs	8/7/18	8/7/18	0.00	0.00	Small Fab-5		<i>38</i>
129	QC	20 pcs	8/7/18	8/7/18	0.00	0.00	QC5		<i>38</i>
130	Packaging	20 pcs	8/7/18	8/7/18	0.00	0.00	Packaging3-1		<i>38</i>
140	QC21-SA	20 Ea	8/7/18	8/7/18	0.00	0.00	QC21		<i>DAS</i> <i>21</i> <i>9-89</i> <i>OCT 26 2018</i>

Part Op 90 - see engineering sign off for lanyard

Descriptions: 110 - Assemble as per DWG. Sheet 2 -Loctite 680 B *13 8 837* Exp: *11/19*
121 - Issue P/O to Groupe Altech; PO *041195* -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
Conformity is required
123 - Receive
127 - Fabricate lanyard 6 inch and Assemble as per DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	<i>60</i> 40 Ea (2 ea)	90-Start up Operation	<i>5038398</i>
91595A142	Dowel Pin Ø3mm x 40mm	<i>30</i> 20 Ea (1 ea)	90-Start up Operation	<i>5093325</i>
CL-2-C	Lanyard Wire	<i>15</i> 10 ft (.5 ea)	90-Start up Operation	<i>5093863</i>
NAS1756-12	Remove Before Flight	<i>30</i> 20 Ea (1 ea)	90-Start up Operation	<i>5094292</i>
RBE350A94-2706-00-07A	Pin Shaft	<i>30</i> 20 Ea (1 ea)	90-Start up Operation	<i>5113633</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	40	947	0
	91595A142	20	202	0
	CL-2-C	10	427	0
	NAS1756-12	20	570	0
	RBE350A94-2706-00-07A	20	<i>20</i>	0



Container No: S114887
Part: FBE350A94-2706-00-07
Job No: 181639
Serial No/ Batch: S114887
Revision: 6
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Newbury, ON K6A 1K7
CANADA
TEL: 1 813 822-5200
Email: sales@dartaero.com
www.dartaero.com

Date: 10/01/18

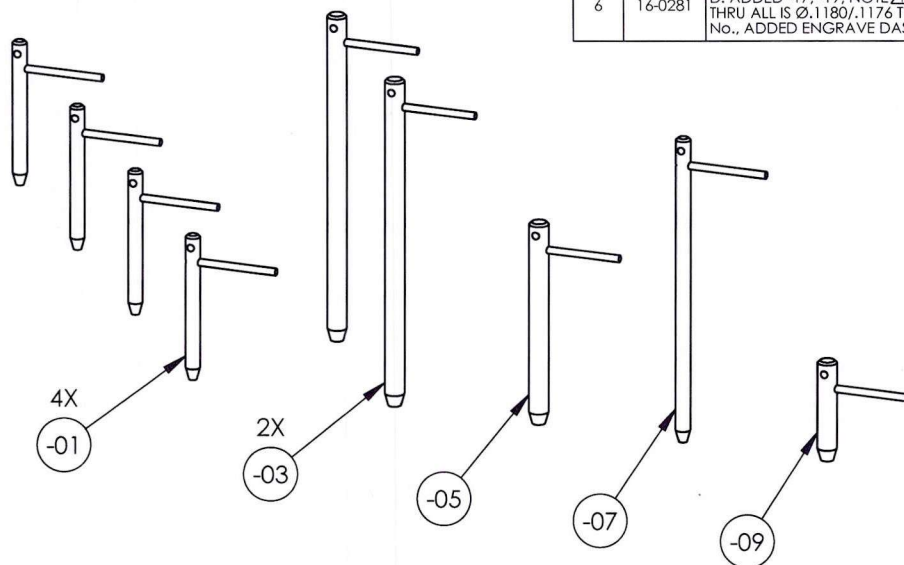
Part Specifications

Specifications could not be found.

Plex 8/2/18 1:54 PM dart.logan.david

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGNED PER HELI PRODUCTS TOOLS.	9/11/2009	WP	DW
2		ADDED ONE MORE -03 PIN, FLAG AND CABLE TIE.	6/14/2010	WP	DW
3		MOVED LENGTH B DIMENSION TO Ø.118in. HOLE CENTERLINE & ADDED 1.5mm TO -01 THRU -09 PINS IN TABLE. ADDED A TOLERANCE TO Ø.118in HOLE TO ACHIEVE A LIGHT PRESS FIT FOR -11. CH'D HOLE FROM Ø.118 TO Ø.113 FOR CABLE TIES. END OF PIN PER S.E.	12/15/2010	RJC	RW
4		CORRECTED PIN VIEW SHEET 1 AND CH'D Ø.113 [Ø2.9mm] HOLE TO Ø.118 [Ø3.0mm] PER G.E.	5/9/2012	RJC	GE
4A		CH'D T/N WAS RBEA94-2706-00 IS RBE350A94-2706-00.	11/6/2013	RJC	RW
5	15-0120	UPDATED TO NEW DRAFTING STANDARDS. CH'D TOLERANCE BLOCK WAS .XXX ± .004 IS .XXX ± .005. ADDED P/N'S -01A, -03A, -05A, -07A, -09A. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	5/26/2015	DPD	JAG
6	16-0281	UPDATED TO DRAFTING STANDARD. -01, -03, -05, -07, -09 ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D. ADDED -17, -19, NOTE Δ. -01A, -03A, -05A, -07A, -09A CH'D DIM WAS 2X Ø.118 ±.001/-000 THRU ALL IS Ø.1180/.1176 THRU ALL (P.F. -11). ADDED DIM Ø.12 THRU ALL. ADDED ENGRAVE DASH No., ADDED ENGRAVE DASH No. COLUMN TO TABLE.	1/12/2017	RJC	JAG



ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				X		-01	4	PIN			2
				1		-01A		PIN SHAFT	O-1	Ø6mm X 3 FT (MCMaster-CARR #88625K65) MODIFIED	3
			X			-03	2	PIN			2
			1			-03A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMaster-CARR #88625K67) MODIFIED	3
		X				-05	1	PIN			2
		1				-05A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMaster-CARR #88625K67) MODIFIED	3
	X					-07	1	PIN			2
	1					-07A		PIN SHAFT	O-1	Ø6mm X 3 FT (MCMaster-CARR #88625K65) MODIFIED	3
X						-09	1	PIN			2
1						-09A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMaster-CARR #88625K67) MODIFIED	3
1	1	1	1	1	B/O	-11		DOWEL PIN	STEEL	Ø3mm X 40mm (MCMaster-CARR #91595A142)	2
					B/O	-13	1	RE-SEALABLE PLASTIC BAG		5 IN X 6 IN APPROX.	N/S
A/R	A/R	A/R	A/R	A/R	B/O	-15		LOCTITE 680			2
1	1	1	1	1	B/O	-17		FLAGS, REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
1	1	1	1	1	B/O	-19		CABLE TIE	BLACK NYLON	(MCMaster-CARR #7189K31)	2
ASSY -09	ASSY -07	ASSY -05	ASSY -03	ASSY -01							



RIGGING PIN SET

TITLE

DWG NO.

RBE350A94-2706-00

REV
6

MAT'L
HEAT
TREAT
FINISH
SPEC

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± 5°
.X ± .1 SURFACES = 125/

DRAWN BY:

PERRITT

CHECKED:

DUERFELDT

OPPS APPR:

ANDERSON

QA APPR:

LINDSAY

APPROVED:

GILBERT

1. BREAK ALL SHARP EDGES
.015 x 45° OR .016R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

USED ON MODEL

EUROCOPTER AS350/355

SCALE

1:3

DATE

9/11/2009

SHEET 1 OF 3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	☐ OTHER : _____			



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER **PO041195**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041195
PO Date: 10/1/18
Due Date: 10/12/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181886	RBEM622U3001101-9	Extractor Bottom -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	10/12/18	2 pcs	0 pcs	2 pcs	\$1.65/pcs	\$3.30

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OCT 12 2018

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PURCHASE ORDER **PO041195**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	181880	RBEM622U3001101-11	Hex Head Cap Screw -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material; Bolt -Certificate of Conformity is required	Firmed	-	10/12/18	6 pcs	0 pcs	6 pcs	\$1.25/pcs	\$7.50
3	182801	RBEM632V4000102-7	Socket Head Cap Screw -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/12/18	6 pcs	0 pcs	6 pcs	\$1.25/pcs	\$7.50
4	180029	RBE350A93-3307-00-01	Retractor -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	10/12/18	21 pcs	0 pcs	21 pcs	\$2.55/pcs	\$53.55
5	179429-A	RBE350A93-3303-02-1	Receiver Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/12/18	18 pcs	0 pcs	18 pcs	\$5.41/pcs	\$97.38

OCT 12 2018

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PURCHASE ORDER

PO041195

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	177794	RBEM652V3002101-M-45	Stud Extension -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	10/12/18	11 pcs	0 pcs	11 pcs	\$2.35/pcs	\$25.85
7	181644	RBE350A94-2706-00-09	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/12/18	21 pcs	0 pcs	21 pcs	\$1.55/pcs	\$32.55
8	181639	RBE350A94-2706-00-07	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/12/18	30 pcs	0 pcs	30 pcs	\$1.50/pcs	\$45.00
9	181640	RBE350A94-2706-00-03	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/12/18	53 pcs	0 pcs	53 pcs	\$1.50/pcs	\$79.50

Grand Total: \$352.13



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PURCHASE ORDER PO041195

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/2/18 3:34 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(013148-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

013148 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-Oct-2018		Aman		041195 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBEM622U3001101-9 ✓ Rev.	RBEM622U3001101-9 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OF EXCESS OIL	OXIDE-BLACK CH	2	2 ✓	0	0	0
2	RBEM622U3001101-11 ✓ Rev.	RBEM622U3001101-11 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OF EXCESS OIL	BLACK-OXIDE CH	6	6 ✓	0	0	0
3	RBEM632V4000102-7 ✓ Rev.	RBEM632V4000102-7 01 -OXIDE BLACK per MIL-C-13924, Class 1	OXIDE-BLACK CH	6	6 ✓	0	0	0
4	RBE350A93-3307-00-01 ✓ Rev.	RBE350A93-3307-00-01 01 -OXIDE BLACK [OXIDE BLACK] MIL-C13964 CLASS 1, MIL-C-16173 GRADE 4	OXIDE-BLACK CH	21	21 ✓	0	0	0
5	RBE350A93-3303-02-1 ✓ Rev.	RBE350A93-3303-02-1 01 -BLACK OXIDE FINISH M MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	18	18 ✓	0	0	0
6	RBEM652V3002101-M-45 ✓ Rev.	RBEM652V3002101-M-45 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OF EXCESS OIL	OXIDE-BLACK CH	11	11 ✓	0	0	0
7	RBE350A94-2706-00-09 ✓ Rev.	RBE350A94-2706-00-09 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	21	21 ✓	0	0	0
8	RBE350A94-2706-00-07 ✓ Rev.	RBE350A94-2706-00-07 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	30	30 ✓	0	0	0
9	RBE350A94-2706-00-03 ✓ Rev.	RBE350A94-2706-00-03 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	53	53 ✓	0	0	0

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BUYER:

DAS
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